

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004455**Date Inspected:** 06-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Jiang Jian Fei	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower and OBG	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present observe and monitor fabrication and perform of the Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**Tower Heavy Machinery Bay 1:**

Caltrans QA observed ZPMC welder Mr. Cao Xiohua performing Submerged Arc welding in the 1G position on Tower Skin Plate C weld ESD1-SA296 A/E-B. Welding appeared to be in conformance with the posted welding procedure specification, WPS-B-T-2221-B-U3C-S-2.

Caltrans QA Inspector observed ZPMC in the process of fitting and tack welding Tower Skin Plate A longitudinal stiffener PJP weld ESD1-SA216 G/K-29.

**Heavy Tower Machinery Bay 3:**

Caltrans QA performed MT verification of ZPMC tested and accepted Deck Panel U-rib welds DP082-001 welds 2 through 6. No relevant indications were noted during verification testing. See MT report TL-6028, generated on this date for further information.

**Summary of Conversations:**

Only general conversations occurred between QA and QC on this date.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshaua Ishibashi, 137 6471 0411, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

---